

Work Order ID 67881

Monday, April 04, 2011 9:04:49 AM

Page 1

Item ID: D3574-1

Accept

Setup Start

Revision ID:

Item Name: Cabin Floor Protector

Stop

Start Date: 4/4/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3574

Rev B

100

0.00

Waterjet

FLOW WATER JET.

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574
Deburr if necessary

□ Dwg Rev:

B

□ Prog Rev:

B

□ 2-

B 11-4-4

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B 11-4-4

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

5/4/04/04

⑩

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

SS 11/6/10

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

150

0.00



Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

Packaging

11/4/10

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Start Date: 4/4/2011 Start Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/5

MF

11-04-05

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, April 04, 2011 9:04:43 AM

Page 1

Work Order ID: 67881



Parent Item: D3574-1



Parent Item Name: Cabin Floor Protector

Start Date: 4/4/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	2,908.715		33.61681			
GE PLASTICS LEXAN SHEET													



RB11-4-4

Location

Loc Qty

Loc Code

MAT018

2908.715789

112585

120

115261

768

116236

2020.71579

112585

①

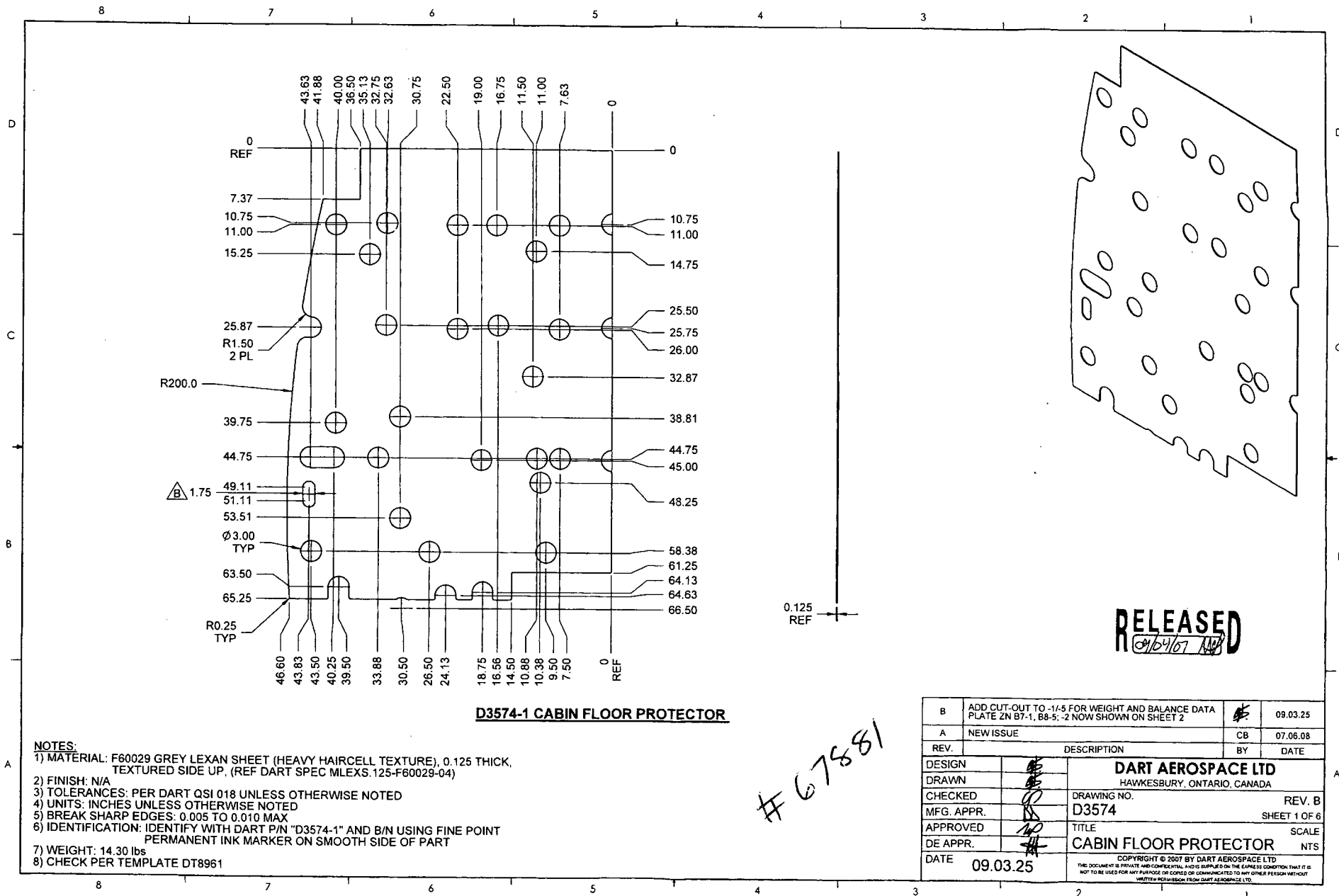
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 67821
Description: Cabin Floor Protector		Part Number: D3574-1
Inspection Dwg: D3574	Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003	x		V HB02	
7.37	+/-0.030	7.37	x		T HB01	
10.75	+/-0.030	10.75	x		T	
11.00	+/-0.030	11.00	x		T	
15.25	+/-0.030	15.25	x		T	
25.87	+/-0.030	25.87	x		T	
39.75	+/-0.030	39.75	x		T	
44.75	+/-0.030	44.75	x		T	
49.11	+/-0.030	49.11	x		T	
51.11	+/-0.030	51.11	x		T	
53.51	+/-0.030	53.51	x		T	
63.50	+/-0.030	63.50	x		T	
65.25	+/-0.030	65.25	x		T	
10.75	+/-0.030	10.75	x		T	
11.06	+/-0.030	11.06	x		T	
14.75	+/-0.030	14.75	x		T	
25.50	+/-0.030	25.50	x		T	
25.75	+/-0.030	25.75	x		T	
26.00	+/-0.030	26.00	x		T	
32.87	+/-0.030	32.87	x		T	
38.81	+/-0.030	38.81	x		T	
44.75	+/-0.030	44.75	x		T	
45.00	+/-0.030	45.00	x		T	
48.25	+/-0.030	48.25	x		T	
58.38	+/-0.030	58.38	x		T	
61.25	+/-0.030	61.25	x		T	
64.13	+/-0.030	64.13	x		T	
64.63	+/-0.030	64.63	x		T	
66.50	+/-0.030	66.50	x		T	
7.50	+/-0.030	7.50	x		T	
9.50	+/-0.030	9.50	x		T	
10.38	+/-0.030	10.38	x		T	
10.88	+/-0.030	10.88	x		T	
14.50	+/-0.030	14.50	x		T	

W/O:		WORK ORDER CHANGES						
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DART AEROSPACE LTD		Work Order: 67881
Description: Cabin Floor Protector		Part Number: D3574-1
Inspection Dwg: D3574	Rev: B	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.56	+/-0.030	16.56	>		T 1B01	
18.75	+/-0.030	18.75	>		T	
24.13	+/-0.030	24.13	>		T	
26.50	+/-0.030	26.50	>		T	
30.50	+/-0.030	30.50	>		T	
33.88	+/-0.030	33.88	>		T	
39.50	+/-0.030	39.50	>		T	
40.25	+/-0.030	40.25	>		T	
43.50	+/-0.030	43.50	>		T	
43.83	+/-0.030	43.83	>		T	
46.60	+/-0.030	46.60	>		T	
7.63	+/-0.030	7.63	>		T	
11.00	+/-0.030	11.00	>		T	
11.50	+/-0.030	11.50	>		T	
16.75	+/-0.030	16.75	>		T	
19.00	+/-0.030	19.00	>		T	
22.50	+/-0.030	22.50	>		T	
30.75	+/-0.030	30.75	>		T	
32.63	+/-0.030	32.63	>		T	
32.75	+/-0.030	32.75	>		T	
35.13	+/-0.030	35.13	>		T	
36.50	+/-0.030	36.50	>		T	
40.00	+/-0.030	40.00	>		T	
41.88	+/-0.030	41.88	>		T	
43.63	+/-0.030	43.63	>		T	
0.125	+/-0.010	.133	>		V 1B02	

Measured by: 1B
Date: 11-4-4

Audited by: S
Date: 11/04/04

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	

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